

**PRODUCTION OF ROLLER SHAFT FOR CAM FOLLOWER WITH ROLLER****Publication number:** JP5179350**Publication date:** 1993-07-20**Inventor:** TSUSHIMA MASAYUKI; HARIMOTO KAZUYOSHI**Applicant:** NTN TOYO BEARING CO LTD**Classification:****- international:** **B21D39/04; C21D9/28; F01L1/18; B21D39/04; C21D9/28; F01L1/18; (IPC1-7): B21D39/04; C21D9/28; F01L1/18****- European:****Application number:** JP19910359845 19911227**Priority number(s):** JP19910359845 19911227**Report a data error here****Abstract of JP5179350**

**PURPOSE:**To enable the easy and inexpensive adjustment of the hardness at both ends of the roller shaft for a cam follower with a roller by subjecting the outer peripheral surface of the above-mentioned roller shaft to high-frequency hardening and tempering, then subjecting only both ends thereof to high-frequency annealing. **CONSTITUTION:**The roller to be supported between a pair of opposite roller supporting members of the cam follower body 1 with the roller is born by interposing needle rollers therein. Both ends of the roller shaft are caulked and fixed to the shaft hole of the roller supporting member. The shaft blank material formed with the end faces is subjected to the high-frequency hardening and tempering to provide the uniform hardness on the surface thereof in the process for production of the above-mentioned roller shaft. Only both ends of the above-mentioned blank material are thereafter subjected to the high-frequency annealing. As a result, the roller shaft which can easily be caulked and molded by adjusting the hardness at the ends of the roller shaft and maintains the proper hardness to the extent of not loosening during use after fixing by caulking is obtd.

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